



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4681-041
Job Sheet 194732



Part No: D4681-041

Job Qty: 8 pcs

Part Name: Web Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/8/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/22/19

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	8 pcs	5/22/19	5/22/19	0.00	6.90	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	8 pcs	5/22/19	5/22/19	0.00	0.00	QC 5 - 10		BB
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		BB
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
121	HAAS 4 Axis - B4B	8 pcs	5/22/19	5/22/19	0.18	5.26	HAAS - 1 - B4B		BB
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
122	QC 2	8 pcs	5/22/19	5/22/19	0.00	0.00	QC 2 - 1		BB
							QC 2 - 12		

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				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
123 QC 8	8	5/22/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Handfinish - 1-1 Chemical-B4B	8	5/22/19	0.00 2.23	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

DAS
64
9-89

M. 2019/07/06

M. 19/07/12

M. 19-7-22

5/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 7	8 pcs	5/22/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
150 Skidtubes - 2 - B4B	8 pcs	5/22/19	0.00 6.90	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	

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160 QC 5	8 pcs	5/22/19	0.00 0.00	Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE MGC
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Packaging 3-1 - Stock - B4B	8 pcs	5/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	Ja
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	5/22/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 SEP 27 2019
L6002				Plex 5/8/19 10:21 AM Dart.lajeunesse.marie	

QC 21 - SA - 53

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 121 - (HAAS CNC Vertical Machine), MILL AS PER DWG AND FOLIO FB186 DWG REV: _____ FOLIO

REV: _____ DEBURR

122 - (QC2- Inspect parts off machine FAI/FAIB)

123 - (QC8- Inspect parts - second check)

130 - (Chemical Conversion Coat per QSI005 4.1)

140 - (QC7-Inspect Chemical Conversion Coat)

150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R

PROSEAL: 3176610 10/19

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: 16002)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	8 pcs (1 ea)	110-Skidtubes - 1	<u>0156872</u>
D4681-3	Doubler	16 pcs (2 ea)	150-Skidtubes - 2 - B4B	<u>5162414+5 32</u>
MS20470AD4-6	Rivet, Universal Head	712 Ea (89 ea)	150-Skidtubes - 2 - B4B	<u>317038-700</u>
				<u>5166917+12</u>

Q2386
x11

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2963-125	8	43	0
150-Skidtubes - 2 - B4B	D4681-3	16	13	0
	MS20470AD4-6	712	4,773	0

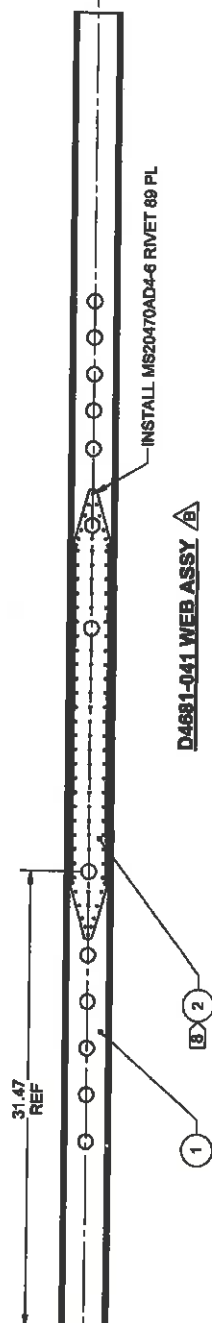
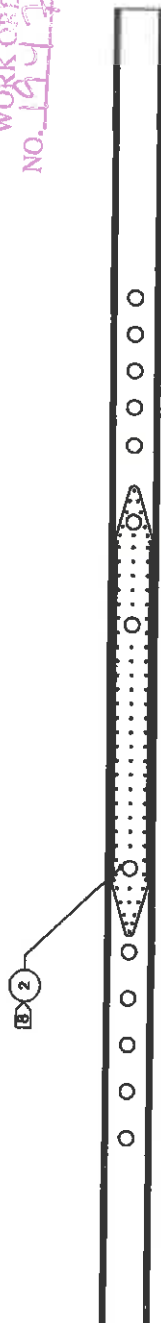
Part Specifications

Specifications could not be found.

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ITEM	QTY	PIN	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	60	MS20470AD4-6	RIVET, PAN HEAD

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194752 HOS
1905-08



D4681-041 WEB ASSY /B/

INSTALL MS20470AD4-6 RIVET 89 PL

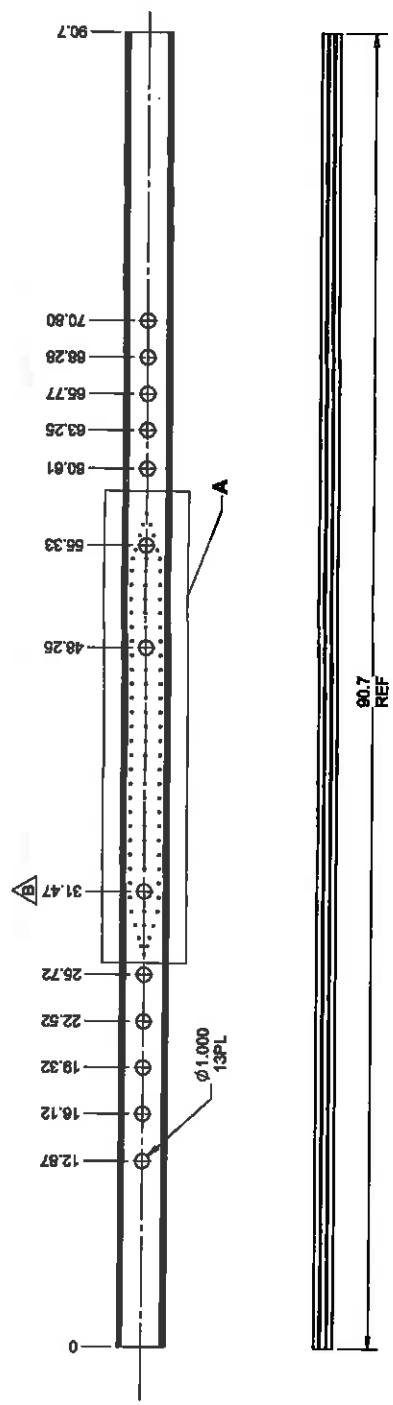
RELEASED
2013-11-13

REV.	DESCRIPTION	AP	BY	DATE
B	MS20470AD4-6 WAS USED INSTEAD OF MS20470AD4-6 RIVET 89 PL. ADDED DETAIL A ON SHEET 2. VARIOUS DIMENSIONAL CHANGES.	AP		13.08.08
A	NEW ISSUE	AP		13.02.13
DESIGN	AP			
DRAWN	AP			
CHECKED	ALS			
MFG. APPR.				
DE APPR.				
DATE	13.08.08			

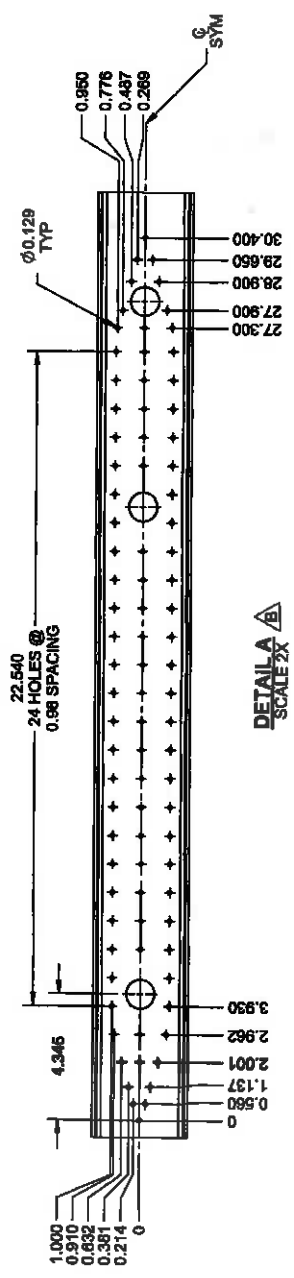
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART PIN "D4681-041" AND BN PER QSI 044 METHOD 6.1
7) WEIGHT: 5.94 lbs
8) SEAL FAYING SURFACES WITH PROSEAL P/S 980 B-1/2 (PRC)

DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO. D4681
REV. B
SHEET 1 OF 4
SCALE
NTS
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1 2 3 4 5 6 7 8



D4681-1 WEB



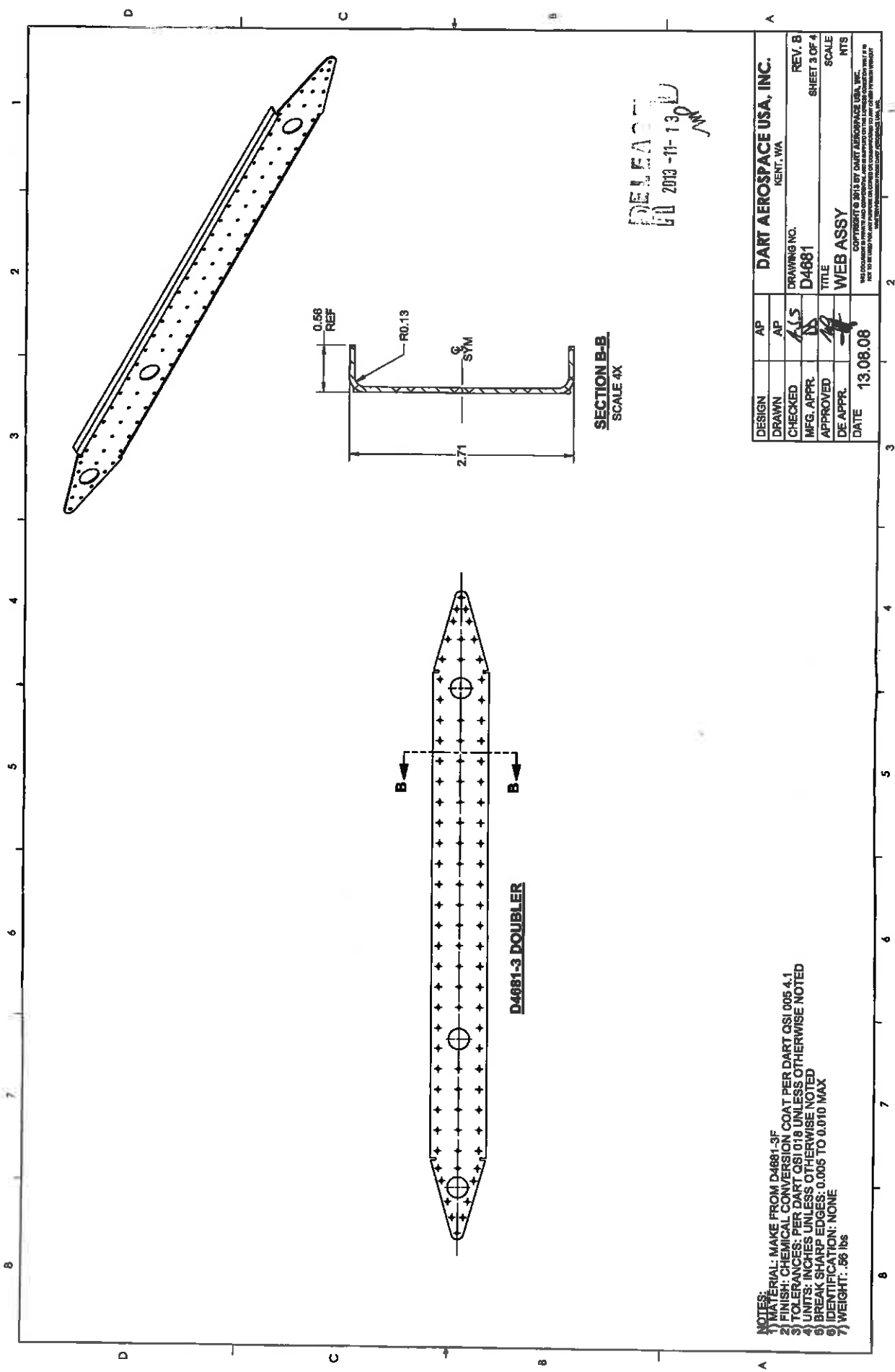
DETAIL A
SCALE 2X

RELEASED
2013-11-13

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.74 lbs

DESIGN	AP	AP	DART AEROSPACE USA, INC.
DRAWN	AP	AP	KENT, WA
CHECKED	AS	AS	DRAWING NO. D4681
MFG. APPR.	AS	AS	REV. B
APPROVED	AS	AS	SHEET 2 OF 4
DE APPR.	AS	AS	SCALE NTS
DATE	13.08.08		TITLE WEB ASSY

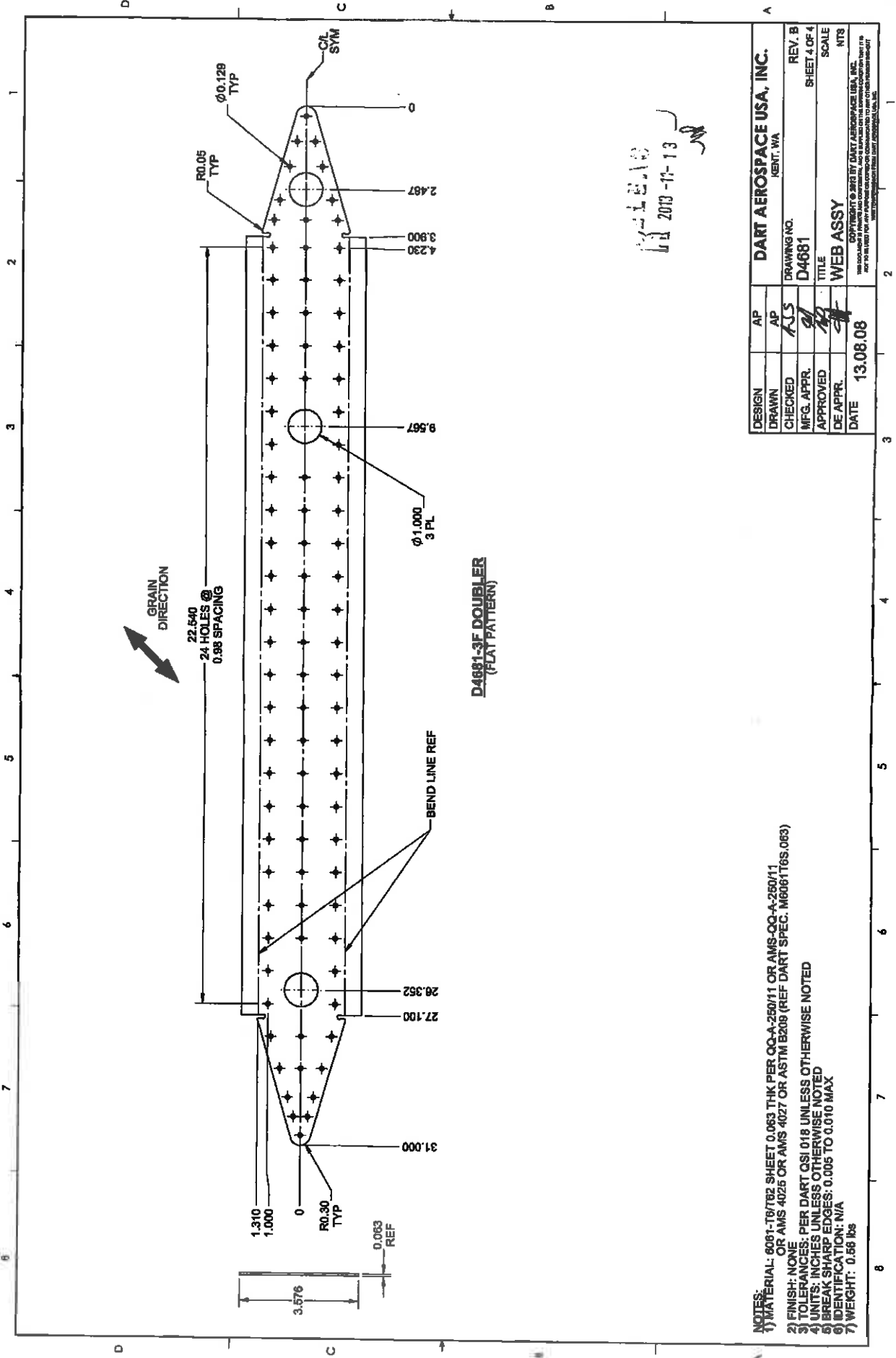
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NOTES:
 1) MATERIAL: MAKE FROM D4681-3F
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: .56 lbs

DESIGN	AP	AP	DART AEROSPACE USA, INC.
DRAWN	AP	AP	KENT, WA
CHECKED	ALLS	DRAWING NO.	REV. B
MFG. APPR.	NS	D4681	SHEET 3 OF 4
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	WEB ASSY	NTS
DATE	13.08.08		

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2013-11-13

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				
Completed By _____		QC / QA Coordinator _____			
Lead hand / Supervisor _____					

